

Work Order ID 58020

April 21, 2010 3:57:51 PM



Page 1

Item ID: D4095-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Wearplate

Start Date: 21/04/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-4-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4095

PA+ 10-4-22

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4095

Dwg Rev: FAR

Prog Rev:

2-Deburr if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

PRELIMINARY ISSUE

QC APPROVAL

SCRAP

10-4-22

10-4-22

→ 8/10/23 #2
inspector to Prod Dwg

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58020

April 21, 2010 3:57:51 PM



Page 2

Item ID: D4095-3

Accept



Setup Start



Revision ID: PRELIM

Item Name: Wearplate

Stop



Start Date: 21/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1- bend section C-C first
2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155
3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157

0.00

0.00

2

10/04/23

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Ensure joggle as per dwg D4095

0.00

0.00

QC APPROVAL

Pho →

150



Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: _____

Large Fab

Memo

same template as D3564-1-3

0.00

0.00

POSITIVE RECALL
EFFECTIVE 10-01-22 AUTH u
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4095-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: [Signature] Date: 10-04-27

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>58020</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/04/23</u>	<u>#140</u>	<u>wear plates Do not fit → ID tube. R.C. Ds in Pak</u>		<u>→ Scrap + Destroy qty x2 → Remake to new Dwg.</u>				<u>[Signature]</u> <u>10/04/23</u>

NOTE: Date & initial all entries

Work Order ID 58020

April 21, 2010 3:57:51 PM



Page 3

Item ID: D4095-3

Accept



Setup Start



Revision ID: PRELIM

Item Name: Wearplate

Stop



Start Date: 21/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____**QC APPROVAL**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58020

April 21, 2010 3:57:51 PM



Page 4

Item ID: D4095-3

Accept



Setup Start



Revision ID: PRELIM

Item Name: Wearplate

Stop



Start Date: 21/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

QC APPROVAL

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W02627

POSITIVE RECALL

EFFECTIVE W02627 AUTH W

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 3:57:56 PM

Page 1

Work Order ID: 58020



Parent Item: D4095-3



Parent Item Name: Wearplate

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:A new issue DD 10.04.21 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

0.0000

2.3076



304/316 Sheet .063

IB 10-4-22

②

304.063

114467

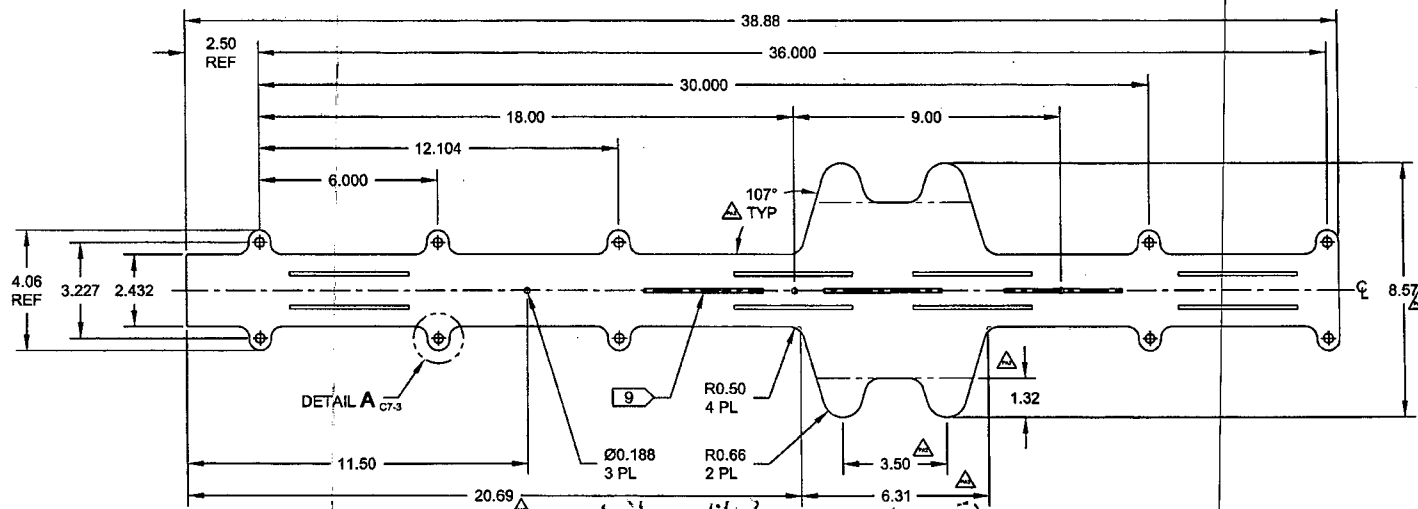
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

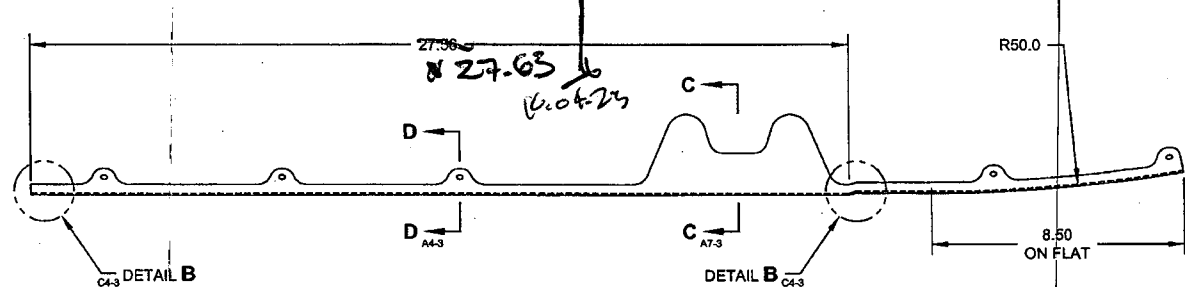
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4095-3F FLAT PATTERN 1



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

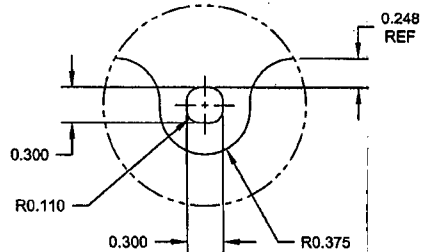
* REASON FOR CHG: TOOLING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56020

10.04.22

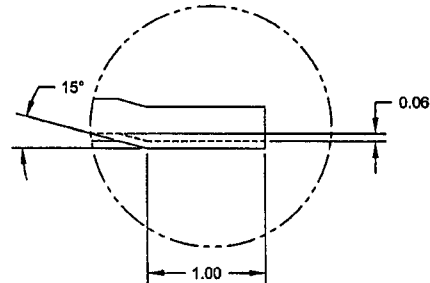
PRELIMINARY ISSUE
10.04.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4095	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



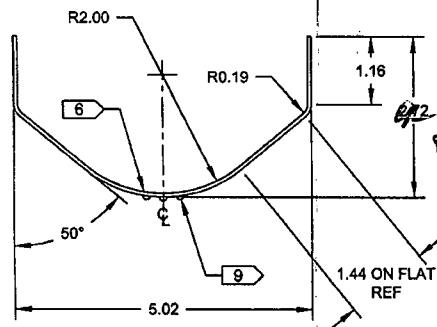
DETAIL A: TAB DETAIL

SCALE 4X C3-1
C8-2



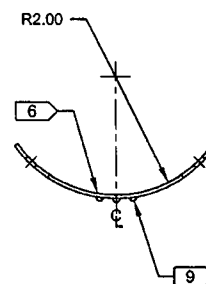
DETAIL B: JOGGLE DETAIL

SCALE 4X B2-1
B6-1
B4-2
B7-2



SECTION C-C

SCALE 2X B5-1
B4-2




SECTION D-D

SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55020

10.04.22

PRELIMINARY ISSUE
10.04.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4095	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DART AEROSPACE LTD		Work Order: 58020
Description: WEAR PLATE		Part Number: D4095-3
Inspection Dwg: D4095-3. Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1300	± .010	1302	X			
350	± .010	363	X			
2.432	± .010	2.435	X			
3.227	± .010	3.224	X			
4.06	± .030	4.055	X			
2.50	± .030	2.502	X			
11.50	± .030	11.50	X			
23.34	± .030	23.34	X			
6.31	± .030	6.31	X			
3.56	± .030	3.50	X			
1.32	± .030	1.333	X			
8.57	± .030	8.568	X			
6.000	± .010	5.997	X			
12.104	± .010	12.104	X			
18.000	± .010	18.000	X			
9.000	± .010	9.000	X			
30.000	± .010	30.000	X			
36.000	± .010	36.000	X			
38.88	± .030	38.875	X			
φ .188	± .005-.001	.189	X			
.063	± .010	.059	X			

Measured by: RB	Audited by: S	Prototype Approval:
Date: 10-4-22	Date: 10/04/23	Date:

inspector to NAB DWG

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	